

ASAP

Dart Aerospace Ltd.

Date: Thursday, 07/12/2006 8:56:28 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG BRACKET
Job Number	: 29623	Part Number	: D27353
Estimate Number	: 10010	Drawing Number	: D2735 REV C
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 07/12/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Revision	: C
First Issue	: 21/11/2006	Type	: SMALL /MED FAB
Previous Run	: 28023	Material	: N/A
Written By	:	Due Date	: 05/12/2006
Checked & Approved By	:	Qty:	40
Comment	: Est Rev:C Removed from 9 Digit 05-10-25 JLM Est. C 06.07.21 waterjet EC	Um:	Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S125	1010-1025 sheet .125 
		Comment: Qty.: 0.1733 sf(s)/Unit Total : 6.9300 sf(s) 1010-1025 sheet .125 batch: M102247 <i>M1 06 12 07</i> (40)
2.0	WATER JET	FLOW WATER JET 
		Comment: FLOW WATER JET 1-Cut as per Dwg D2735 Dwg Rev: C <i>06 12 07</i> (10) Prog Rev: C
		2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <i>M1 06 12 07</i> (40)
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK 
		Comment: SECOND CHECK <i>06/12/07 (40)</i>
5.0	BRAKE NC	NC BRAKE 
		Comment: NC BRAKE 1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204 2-Deburr if required. <i>SB 06/12/12 (40)</i>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

DQA: HDate: 06/12/14

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Date: Thursday, 07/12/2006 8:56:28 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 29623

Part Number: D27353

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



*2007-06-12 40*



Comment: INSPECT WORK TO CURRENT STEP

*06/12/13*

7.0 PACKAGING 1

PACKAGING RESOURCE #1



(40)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W523

*CPL 06-12-13*

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

*2007-06-12-14*

Job Completion



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

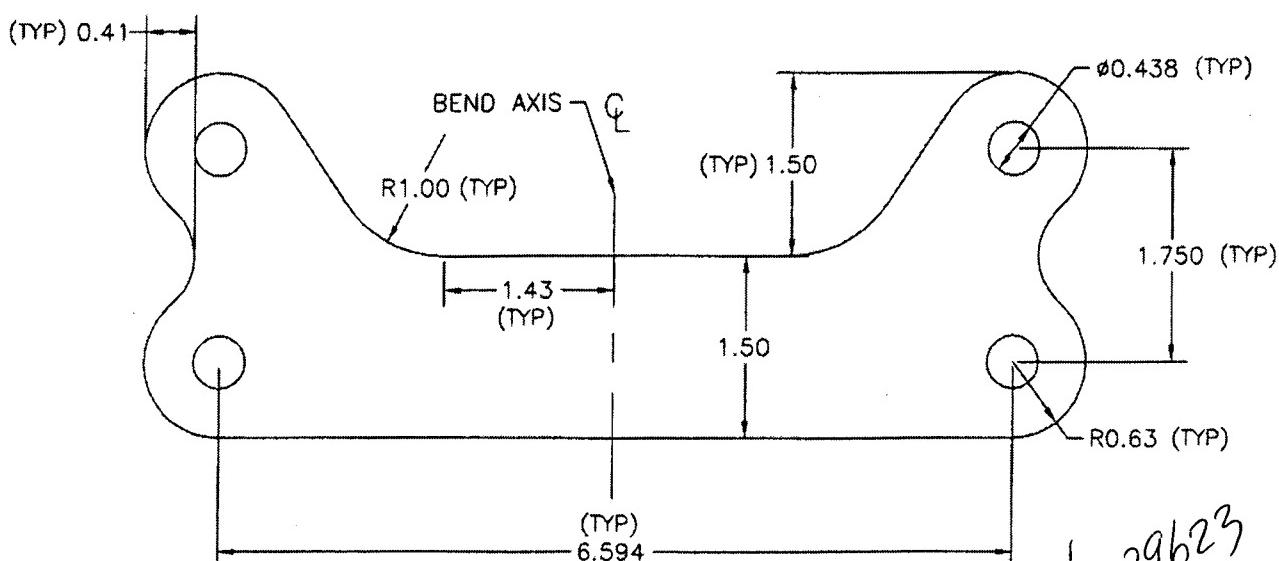
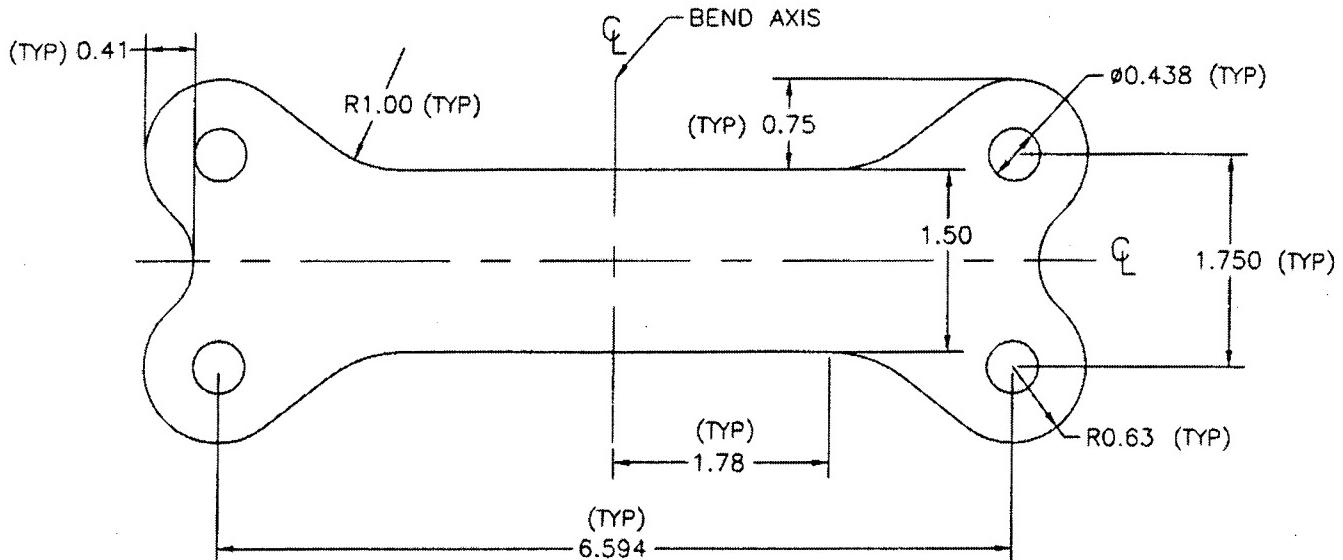
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
<i>CP</i>	<i>KE</i>	D2735	SHEET 1 OF 2
DATE		TITLE	SCALE
98.12.14		LUG BRACKET	2:3
A	97.12.14	NEW ISSUE	
B	98.10.23	UPDATE MATERIAL (TSR A1114)	
C	98.12.14	REMOVE TOOLING HOLES (TSR A1040)	

**RELEASED**  
98.12.14 DS

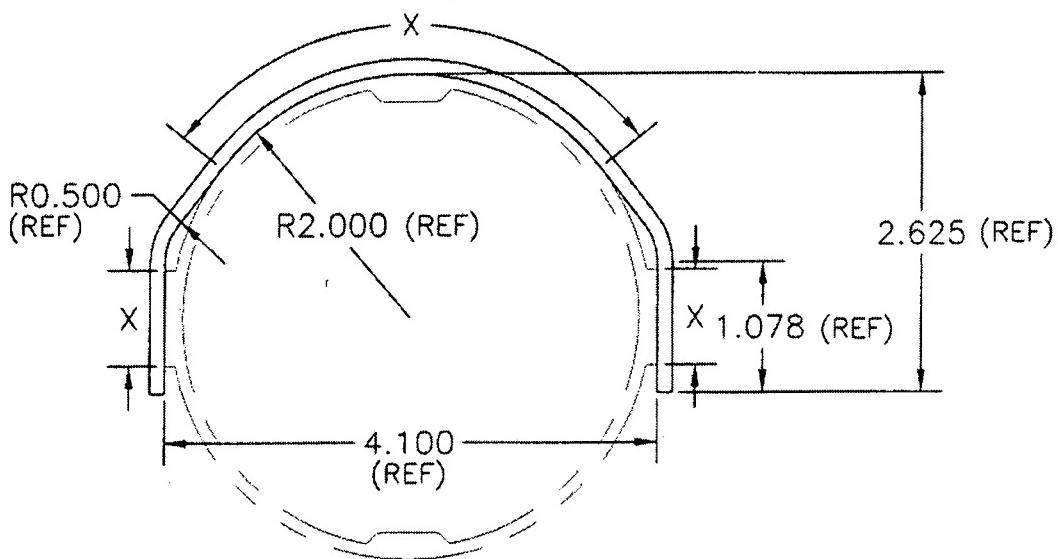


**DART**

DESIGN <i>PF</i>	DRAWN BY <i>PF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>DP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735
DATE 98.12.14		TITLE LUG BRACKET

REV. C  
SHEET 2 OF 2  
SCALE  
2:3**RELEASED**

98.12.14 DS

D2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL  
0.125 THICK (11 GAUGE)  
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

*W.D. 29/6/97*

**DART AEROSPACE LTD**

**Work Order:** 29623

Description: Lug bracket

**Part Number:** D2735-3

Inspection Dwg: D2735 Rev: C

Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## **X First Article      X Prototype**

Measured by:	<u>M.C. Mcl</u>
Date:	<u>06/12/07</u>

Audited by:	
Date:	06/12/07

<b>Prototype Approval:</b>	
<b>Date:</b>	

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	